

Rush

Work Order ID 148803

148803

Page 1

July 08, 2016 10:35:27 AM

Item ID: PB67-43001-47

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Base Assembly

Start Date: 7/8/2016 Start Qty: 3.00

Required Date: 8/3/2016 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: SH Date: 7/12/16 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-47	Rev C
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100		0.00							
100	Large Fab								
Large Fab	Memo	0.15							
Large Fab	1- weld as per dwg B67-43001 using jig								

3 JUL 20 2016 DAS 24 9.50

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									

③ 16.07.22 ④

120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

③ 16.07.21 ④

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Work Order ID 148803

July 08, 2016 10:35:27 AM

148803

Page 2

Item ID: PB67-43001-47

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base Assembly

Start Date: 7/8/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>MEZZ2</i>	0.00				<i>3</i>	JUL 26 2016		DAS 24 9-89
130	Packaging	Memo							
	Packaging	LOCATION: Mezz 2							
140	QC21- Final Inspection - Work Order Release	0.00							
140	QC	Memo							DAS 21 9-89
	Quality Control								

DAS
21
9-89

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
			OTHER : ☐					

Picklist Print

Monday, July 18, 2016 9:09:53 AM

Page 1

Work Order ID: 148803

Parent Item: PB67-43001-47

Parent Item Name: Base Assembly

148803

PB67-43001-47

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: A 08-06-25 new issue DD verified by: ec
10.09.28 per rev C dwg EC verified by: DD

IPP Rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3440-11		Manufactured	No			100	Each	2.0000	2	6			DAS 24 9-89
D3440-11 Gusset (Supersedes B67-43001-241)													

** JUL 20 2016

3148804 → 4

Location	Loc Qty	Loc Code
Mezz2	2	
111723	2	
PB67-43001-139		
Manufactured	No	
PB67-43001-139		
Square Tube		
100	Each	1.0000
1	3	
** JUL 20 2016		
3148805 → 2		

Location	Loc Qty	Loc Code
Mezz2	1	
100003	1	
PB67-43001-141		
Manufactured	No	
PB67-43001-141		
Square Tube		
100	Each	8.0000
2	6	
** JUL 20 2016		
3148805 → 2		

Location	Loc Qty	Loc Code
Mezz2	8	
133696	2	
142327	6	
PB67-43001-143		
Manufactured	No	
PB67-43001-143		
Square Tube		
100	Each	6.0000
2	6	
** JUL 20 2016		
3148805 → 2		

Location	Loc Qty	Loc Code
Mezz2	6	
142553	6	
PB67-43001-143		
Manufactured	No	
PB67-43001-143		
Square Tube		
100	Each	6.0000
2	6	
** JUL 20 2016		
3148805 → 2		

DAS
24
9-89

Picklist Print

July 08, 2016 10:35:27 AM

Page 2

Work Order ID: 148803

148803

Parent Item: PB67-43001-47

PB67-43001-47

Parent Item Name: Base Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-315

Manufactured No

100

Each

12.0000

3

PB67-43001-315

9 JUL 26 2016

Hook

**DAS
24
9-83**

Location

Loc Qty

Loc Code

Mezz2

12

146157

12

9

DQA: _____ Date: _____

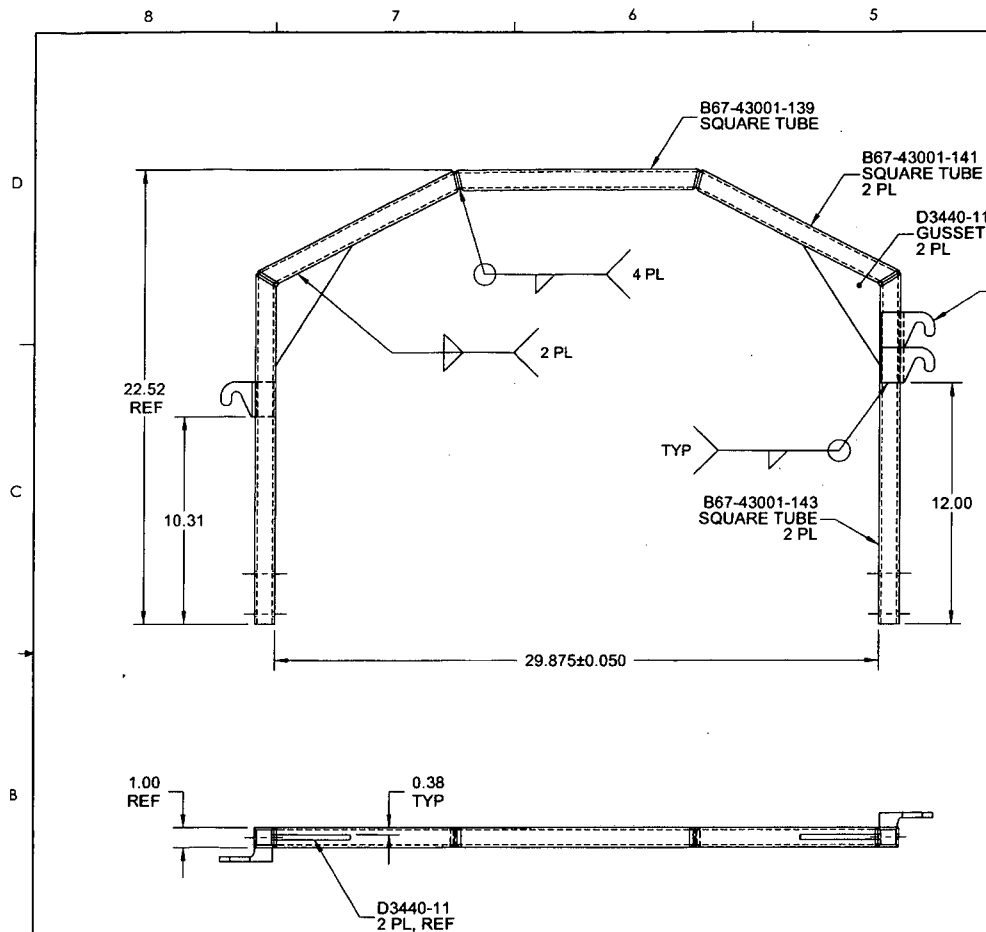


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

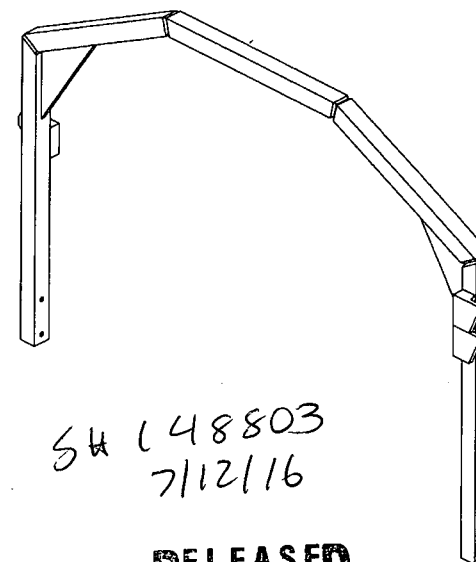
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B67-43001-47 BASE ASSEMBLY

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 3.68 lbs
 - 8) WELDING: PER QSI 004

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-139	SQUARE TUBE
4	2	B67-43001-141	SQUARE TUBE
5	2	B67-43001-143	SQUARE TUBE
6	3	B67-43001-315	HOOK
7	2	D3440-11	GUSSET



SW 148803
7/12/16

RELEASED
2010-08-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C	SHEET 1 OF 1
DRAWN				
CHECKED		DRAWING NO.		
MFG. APPR.		B67-43001-47		
APPROVED		TITLE	SCALE	
DE APPR.	N/A	BASE ASSEMBLY	NTS	
DATE	09.06.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		